

Ship 24/10

Dart Aerospace Ltd.

Date: Thursday, 18/10/2007 1:22:18 PM
User: Linda Lacelle

SP18

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35240
Estimate Number : 12660
P.O. Number : N/A
This Issue : 18/10/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 33356
Written By :
Checked & Approved By :
Comment : Est Rev A New Issue 07-01-22 EC

Drawing Name : CABIN FLOOR PROTECTOR
Part Number : D35741
Drawing Number : D3574 REV.A
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 24/10/2007 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 F60029 lexan grey



Comment: Qty.: 32.0000 sf(s)/Unit Total: 128.0000 sf(s)

F60029 lexan sheet

Batch: 105330 1B 07-10-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3574

Dwg Rev: A

Prog Rev: A

1B 07-10-19

(4)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B 07-10-19

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

E 09/10/19

counters

(44)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 07/10/20

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 27/10/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 18/10/2007 1:22:18 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 35240

Part Number: D35741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/10/22 (XCO)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

09/10/22 (E)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/10/22 (A)

Job Completion



U 09/10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

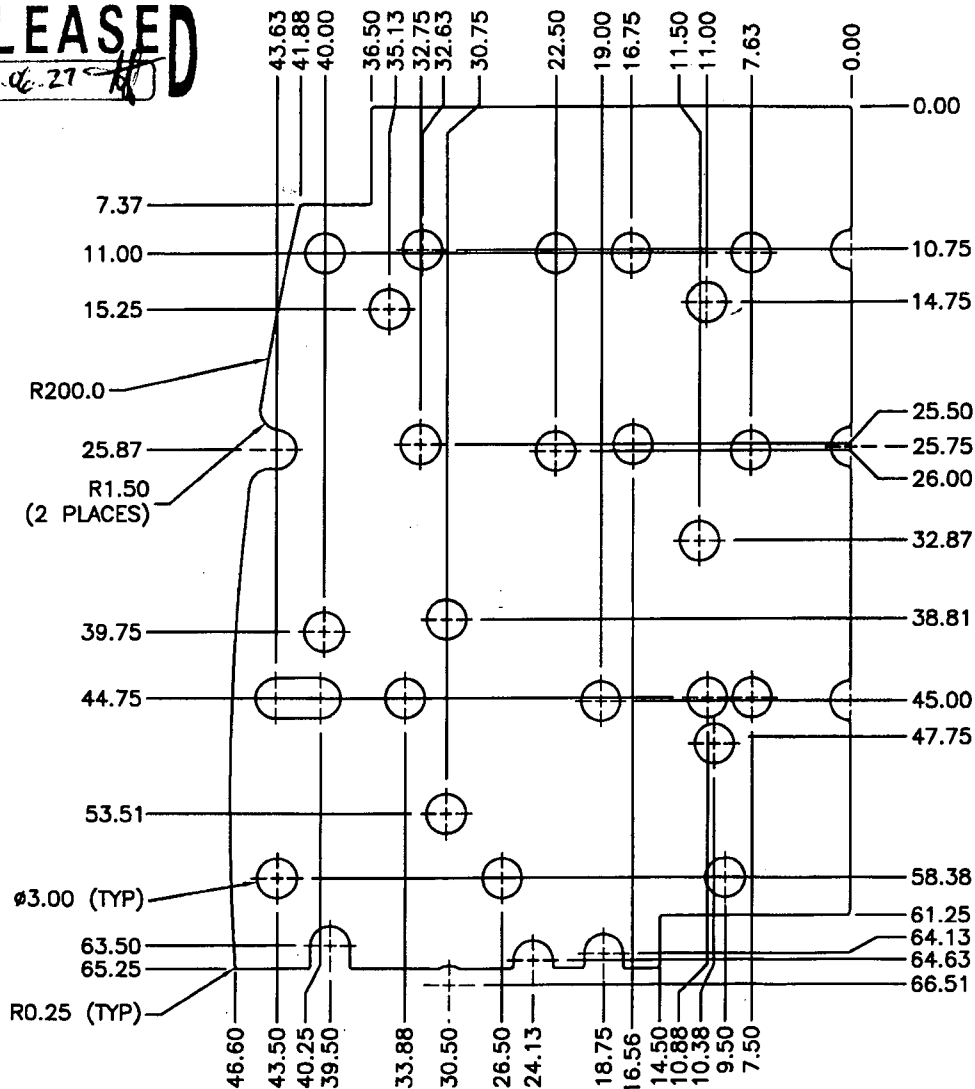
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07-06-27**D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 35240
Description: CABIN FLOOR PROTECTOR		Part Number: D3574-1
Inspection Dwg: D3574-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+/- .012 - .001	2.999 *				
7.37	+/- .030	7.37 *				
11.00	+/- .030	11.00 *				
15.25	+/- .030	15.25 *				
25.87	+/- .030	25.87				
39.75	+/- .030	39.75				
44.75	+/- .030	44.75				
53.51	+/- .030	53.51				
63.50	+/- .030	63.50				
65.25	+/- .030	65.25				
10.75	+/- .030	10.75				
14.75	+/- .030	14.75				
25.50	+/- .030	25.50				
25.75	+/- .030	25.75				
26.00	+/- .030	26.00				
32.87	+/- .030	32.87				
38.81	+/- .030	38.81				
45.00	+/- .030	45.00				
47.75	+/- .030					
58.38	+/- .030	58.38				
61.25	+/- .030	61.25				
64.13	+/- .030	64.13				
64.63	+/- .030	64.63				

Measured by: LB
Date: 07-10-19

Audited by: E
Date: 07/10/19

Prototype Approval: <i>[Signature]</i>
Date: <i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

